

Work Order ID 86584

86584

Page 1

July-05-12 1:14:06 PM

Item ID: D2989-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 7/05/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: CY Date: 12/07/05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig

****cut cutouts with zip cut as per dwg D3832****

3- remove from jig and weld lable plate as per dwg D2989

A/R ER316 S.S. Rod Batch: 17/22130

*** PLEASE NOTE****

IF MAKING -043A :

ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER

DSI9473

CPC / CC 12-8-23

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

1 φ 12-08-23 18 18 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							

DAS
16
9-83
12/08/23

MA
12/08/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

131

Wing Walk as per dwg QSI005 4.4 Batch 122320 0.00

131

HandFinish

Hand Finishing

Memo

0.00

Mask lid prior to spray paint black and wing walk as per dwg

A/R Spray paint black batch: 120817

IX 12/08/23

1 8 2P 12/08/24

W121841

2:00
4000F
2:30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 86584***86584***

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July-05-12 1:14:06 PM

Item ID: D2989-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Lid Assembly

Start Date: 7/05/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

/ ϕ BL 12-8-24

141

Identify as per dwg & Stock Location: 0350-607-043 0.00

0.00

141

Packaging

Memo

0.00

Packaging

87537 ✓

1 Δ (20) 12/08/27

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

CK 12/8/28MF
12-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

July-05-12 1:14:06 PM

Page 1

Work Order ID: 86584
Parent Item: D2989-041
Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M 10.09.14 added pressure wash DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2221-1 Rib		Manufactured	No			100	Each	8.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				83907		8							
✓ D2506 Label Plate		Manufactured	No			100	Each	12.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		12							
				79197		1							
				82705		11							
✓ D2512-7 Rib		Manufactured	No			100	Each	8.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				53444		0							
				77522		4							
				81048		4							

386847 → (1x) 12-08-10
82950 → (1x)

(1x) CC 12-8-22
12-08-10

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 86584
Parent Item: D2989-041
Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12
Start Qty: 1.00

Required Date: 8/03/12
Required Qty: 1.00

✓ D2581
Mounting Bracket

Manufactured No

100 Each 61.0000

2

B86961 → (1x) 12.08.10

Location	Loc Qty	Loc Code
WA	39	
82506	2	
83230	3	
85436	10	
85452	24	
WA005	22	
70766	2	
81253	1	
82897	19	

✓ D2989-13
Rib

Manufactured No

100 Each 4.0000

2

(1x) B77528 → 2x 12.08.10

Location	Loc Qty	Loc Code
WA	4	
84604	4	

✓ D2989-19
Rib

Manufactured No

100 Each 10.0000

2

2 12.08.10

Location	Loc Qty	Loc Code
WA	10	
77519	4	
84603	6	

D3832-3
Mesh (Lid)

Manufactured No

100 Each 1.0000

1

1 CC 12-8-23

Location	Loc Qty	Loc Code
WA035	1	
77520	1	

B 86576 → (1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 86584

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

✓ D3833-3 Mesh (Lid End) Manufactured No

100 Each 13.0000 2 2

Location

Loc Qty

Loc Code

WA 81142
WA035 67460

4 B87413 →
4 B87051 →
9
9

(1x) CC 12-8-22
(1x)

✓ D3836-041 Rib Assembly (Basket Lid, LH) Manufactured No

100 Each 4.0000 1

Location

Loc Qty

Loc Code

WA 77515

4
4

B87890 → 1x 12.08.10

✓ D3836-042 Rib Assembly (Basket Lid, RH) Manufactured No

100 Each 4.0000 1

Location

Loc Qty

Loc Code

WA005 77514

4
4

B84796 → 1x 12.08.10

✓ D3852-041 Rib Assembly Manufactured No

100 Each 6.0000 1

Location

Loc Qty

Loc Code

WA005 77512
86042
86154

6
2
2
2

B86042 → 1x 12.08.10

✓ D3852-042 Rib Assembly Manufactured No

100 Each 5.0000 1

Location

Loc Qty

Loc Code

WA 77513
WA005 66089
77513
86043

1
1
4
1
1
2

B77513 1x 12.08.10

July-05-12 1:14:06 PM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

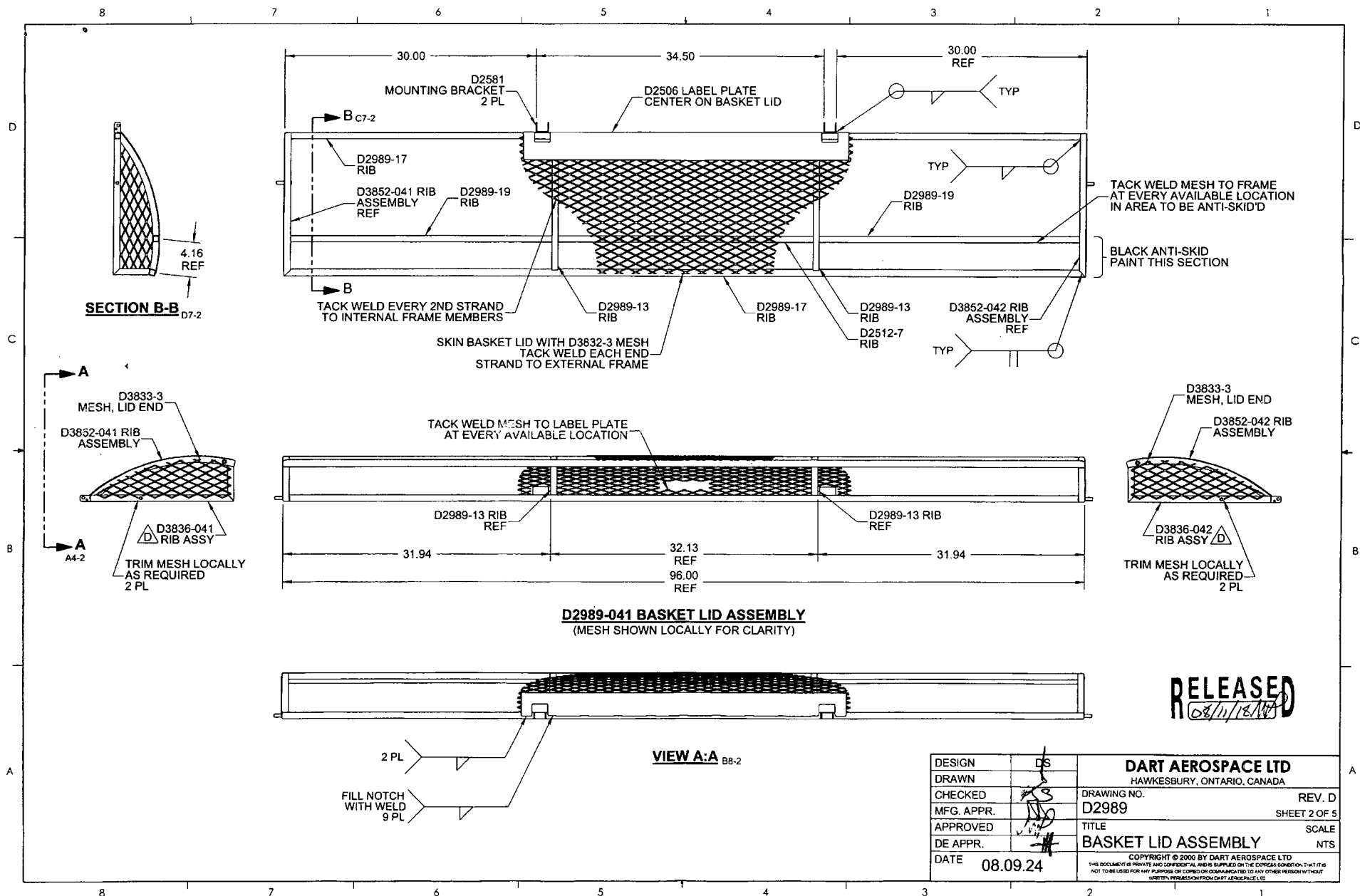
RELEASED
08/11/18 MTD

CD12107105
W10: 86584

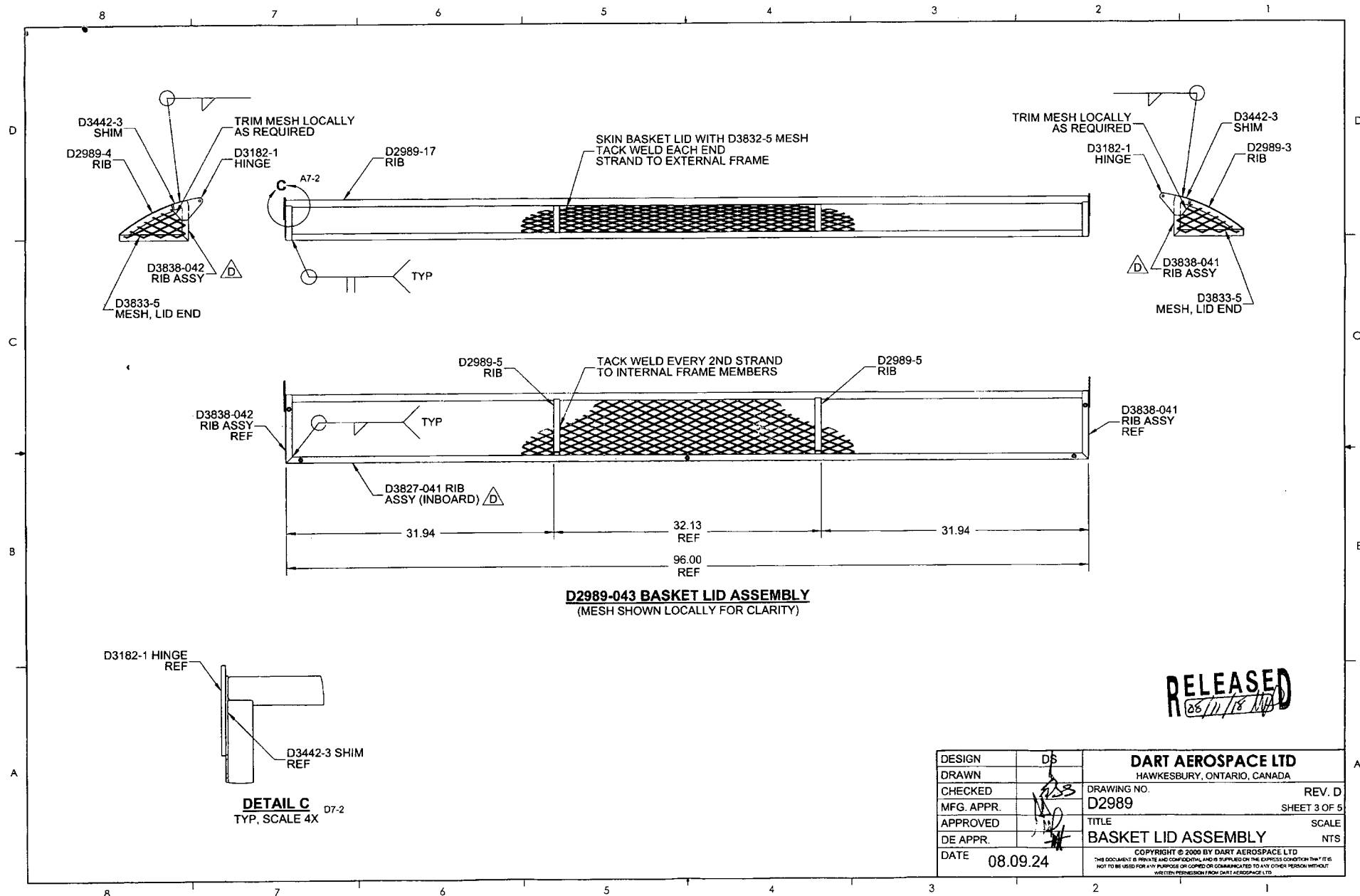
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3838 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-12 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED	AJS	D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE AND IS TO REMAIN THE PROPERTY OF DART AEROSPACE LTD.	
DATE	08.09.24		

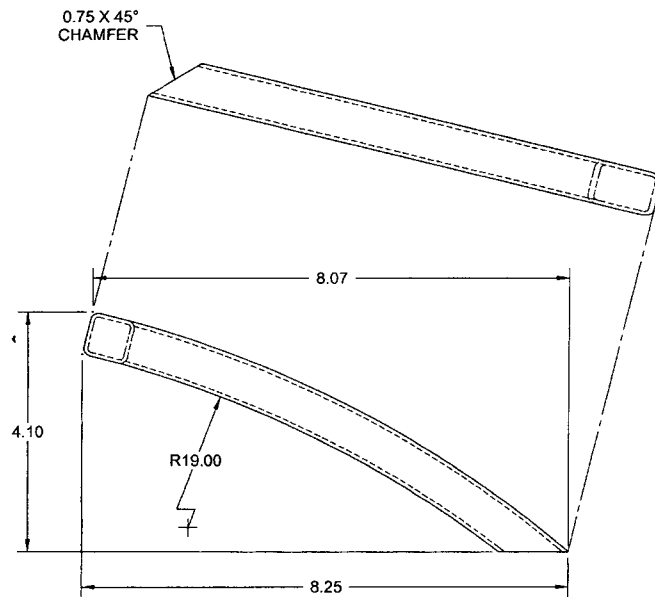
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

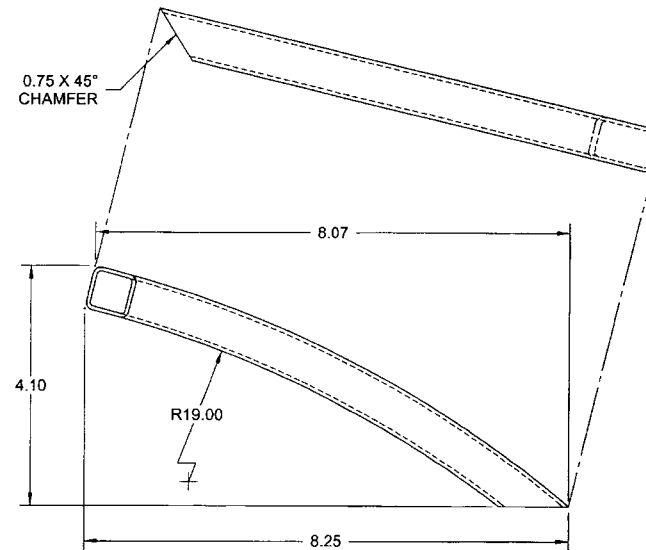


DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

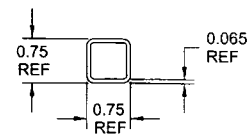




D2989-3 RIB



D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

